

Date: Friday, 5/25/2007 8:19:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-BOLT SPACER
Job Number : 32597	
Estimate Number : 12324	
P.O. Number : <u>N/A</u>	Part Number : D34905
This Issue : 5/25/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3490 REV A
Prsht Rev. : <u>NC</u>	Project Number : <u>N/A</u>
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : <u>A</u>
Previous Run : 29870	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 5/31/2007 Qty: 50 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev. A New Issue 06-03-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T03125W058	ALUM. SEAMLESS TUBE
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Comment: Qty.: 0.2793 f(s)/Unit Total : 13.9650 f(s)
 6061-T6 Tube 500 x .049W — m6061T6T03125W058 cd.
 (M6061T6T0 500W.049)
 Batch: M104676

MS 07/06/11

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA630 & DWG D3490
 FOLIO REV: AA
 DWG REV: A

2-DEBURR AS REQUIRED

DSP 07/06/12

MS 07/06/11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSP 07/06/12

MS 07/06/11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S.F 07/06/11

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1





Identify and Stock

Location: LC BE 07-06-12

154

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/06/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/12	2.0	61 parts vary from 0.001" to 0.003" under size, on A - 0.00" tolerance. Deviation caused by the tool offset	 QS10412	Parts are acceptable.	BE 07-06-12	 07-06-12	 QS10412	 0706.12

NOTE: Date & initial all entries

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Drawing Name: X-BOLT SPACER

Job Number: 32597

Part Number: D34905

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



154

Comment: FINAL INSPECTION/W/O RELEASE

07/06/14

Job Completion



U 7.86.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

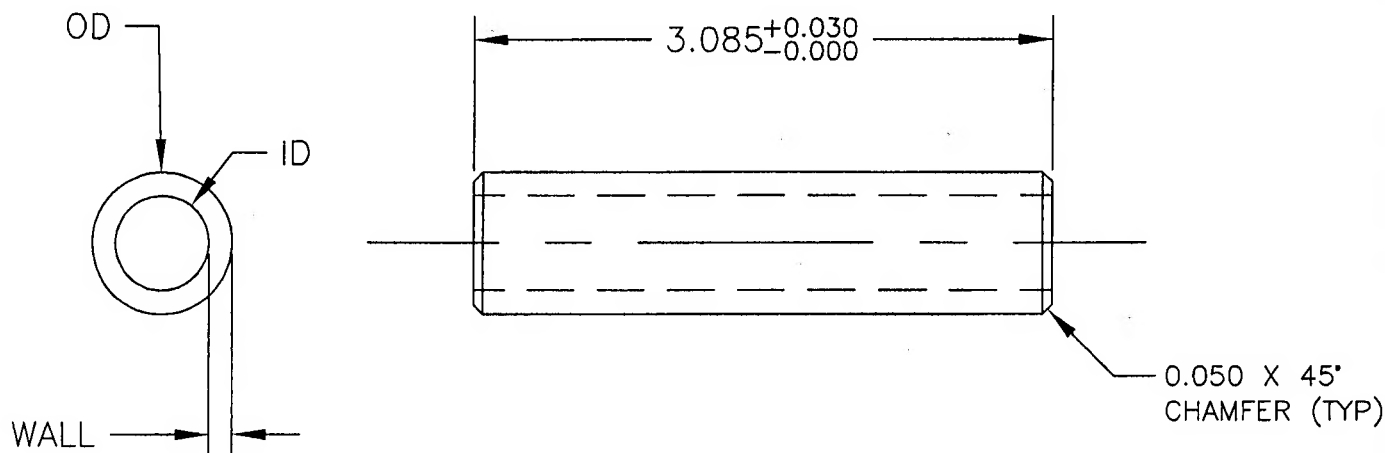
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	

**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **32597**

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
do-02-07

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